

34552 DREV

Work Order ID 53507

November 6, 2009 4:08:37 PM



Page 1

Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *R*

Date: 09/11-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3798

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-2

same flat paterne as D3798-1

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

6061

.000

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

template D3798-1T1

 B 9-11-18

 B 9-11-8

②

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Item ID: D3798-042	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Spacepod Floor					
Start Date: 06/11/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 13/11/2009	Req'd Qty: 4.00		Customer:		
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo ***template D3798-1T1***	0.00 0.00							
			z> 509/11/26			(x2)	/		
130 Small Fab Small Fab	Memo 1- C'sink as per dwg D3798-2 2- Deburr if necessary	0.00 0.00							
						509/11/26 (2)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			z> 509/11/26			(x2)	/		

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Item ID: D3798-042

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Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3798-2 to D3798-5 as per dwg

M 09/11/26

X2

Ø

BR 09-11-26

②

9/11/26 ②

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Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

0.00



Small Fab

Memo

0.00

Small Fab

1-Install foam as per dwg D3798 using contact cement

A/R Contact Cement batch: B112983

2- Trim foam if necessary

RC 09 12-11

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2> S or 12/11



230

Identify as per dwg & Stock Location: 241B

0.00



Packaging

Memo

0.00

Packaging

9/12/11 24 SL

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Item ID: D3798-042

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Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14

PC 09/12/11
(2)

Picklist Print

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Page 1

Work Order ID: 53507

Parent Item: D3798-042RevA

Parent Item Name: Spacepod Floor

Comments:

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

36.5753

37.0274



6061-T6 .050 Sheet

189-11-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

36.57523158

110791

34.5715

112567

0.00373158

17349

2

D3798-5

Manufactured

No

170

Each

4.0000

4.0000



Reinforcement

113189 x 2

2

Ep 509/11/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

4

52807

4

MS20426AD4

Purchased

No

170

Each

3,030.000

132.0000



Rivet

2

Ep 509/11/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3030

113064

3030

115541

Picklist Print

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Work Order ID: 53507



Parent Item: D3798-042RevA



Parent Item Name: Spacepod Floor



Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3798-3RevA		Manufactured	No			210	Each	3.0000	4.0000			
												
Spacepod Floor Foam												

21 09-12-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

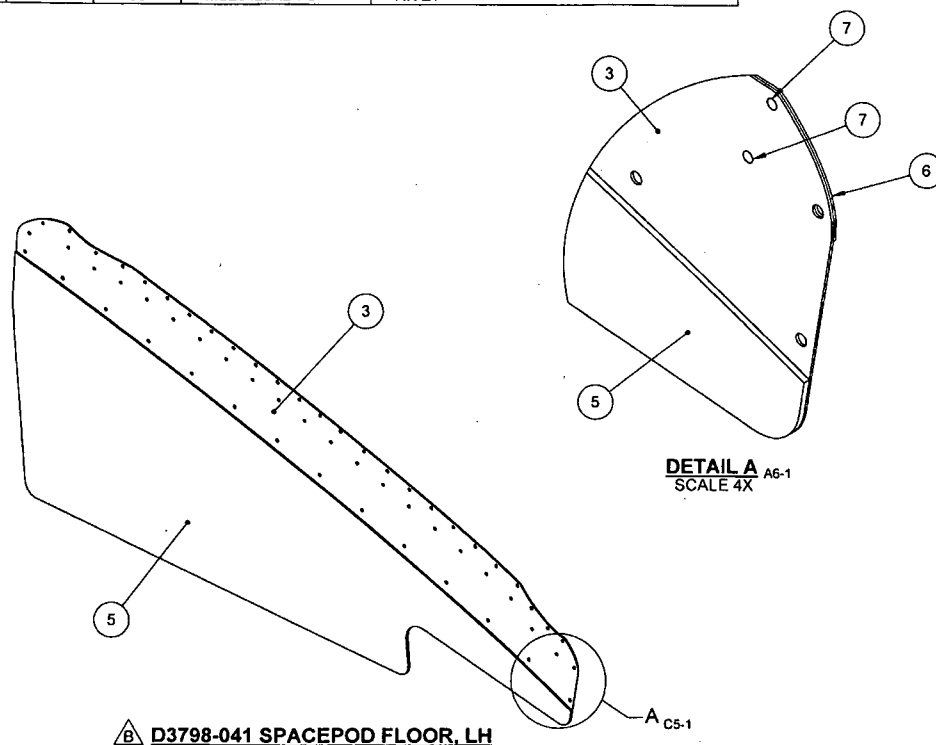
3

51098

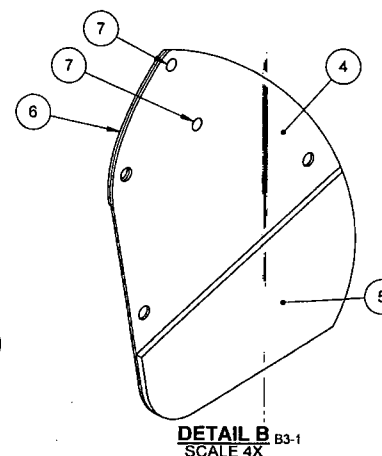
3

B 53904 x 2

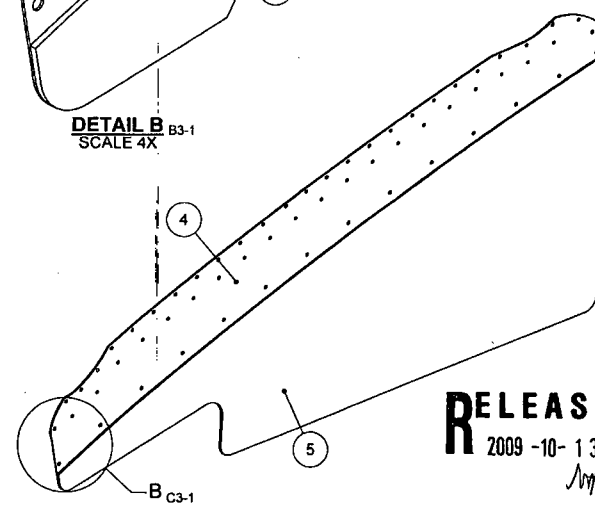
ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



B D3798-041 SPACEPOD FLOOR, LH



**DETAIL B B3-1
SCALE 4X**



B D3798-042 SPACEPOD FLOOR, RH

NOTES:

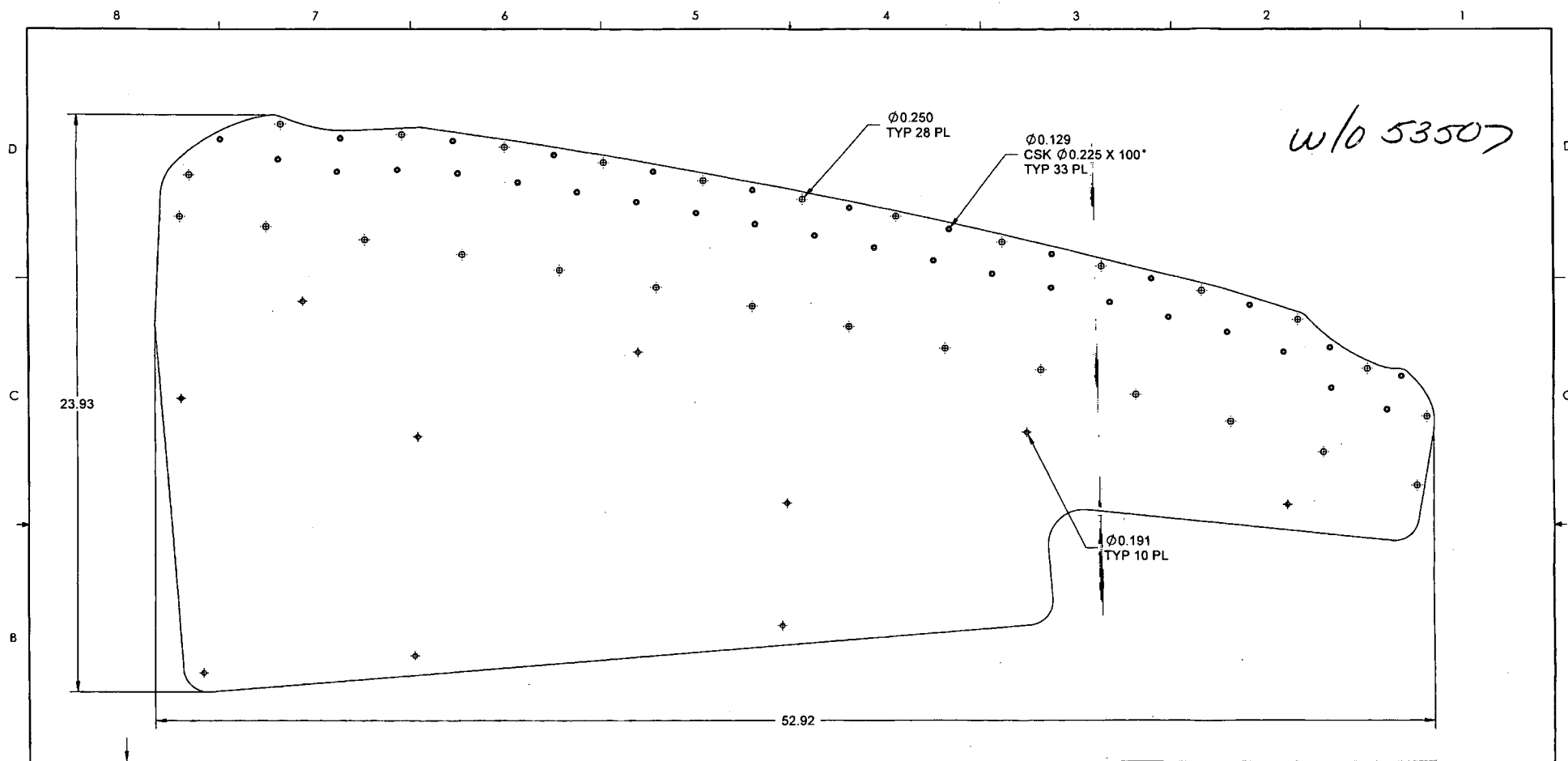
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs
D3798-042 - 5.0 lbs

- B 8) ASSEMBLY INSTRUCTIONS**
- RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
 - POWDER COAT PER NOTE 2
 - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

UNCLASSIFIED
SUBJECT TO
WITHIN THE
WORK
NO. 53502
BP 0911-P

RELEASED
2009-10-13
MP

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.10.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3798 TITLE SPACEPOD FLOOR REV. B SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



D3798-1 SPACEPOD FLOOR

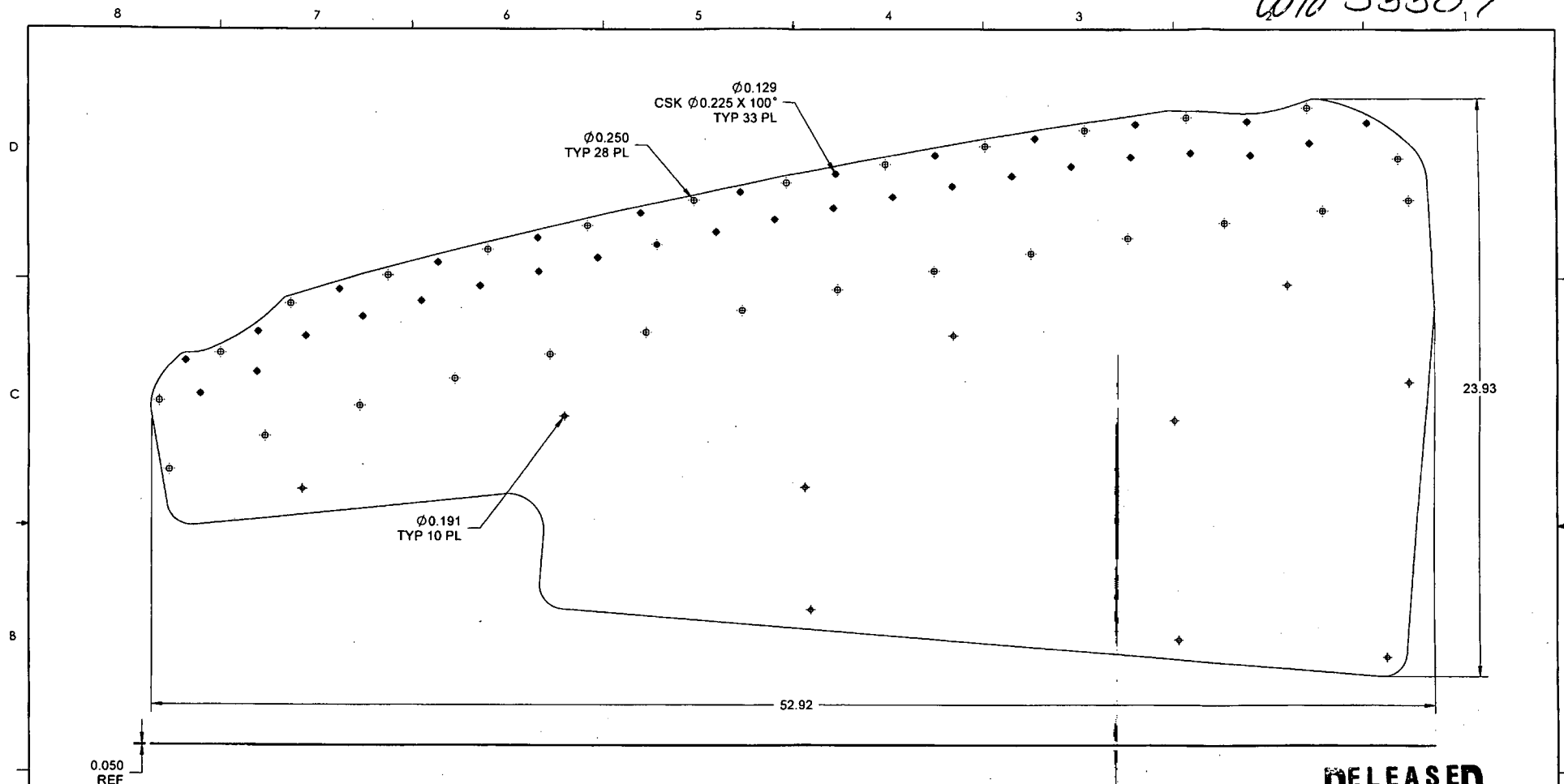
RELEASED
2009-10-13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3798	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
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W/O 53507



D3798-2 SPACEPOD FLOOR

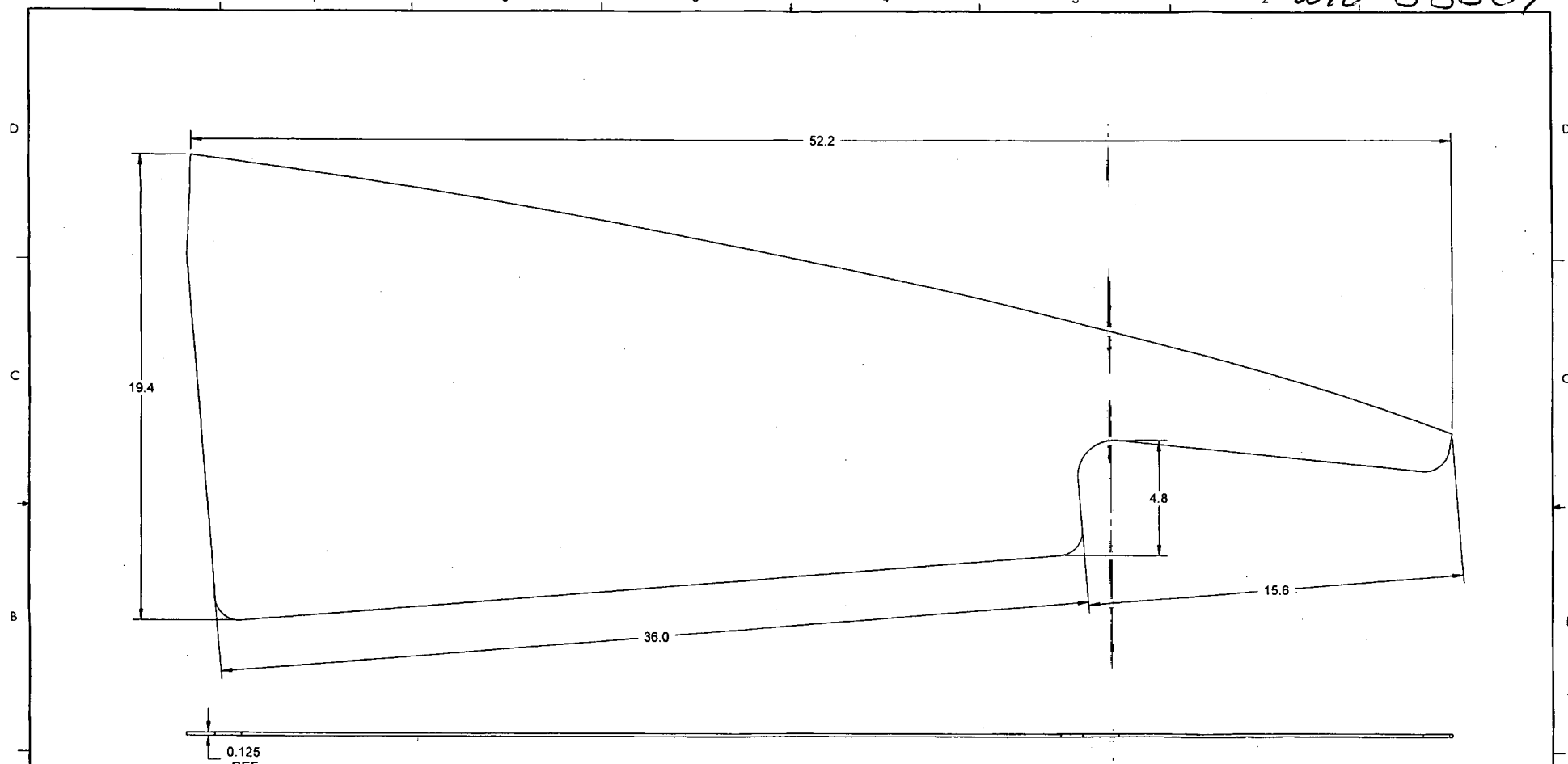
RELEASED
2009-10-13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
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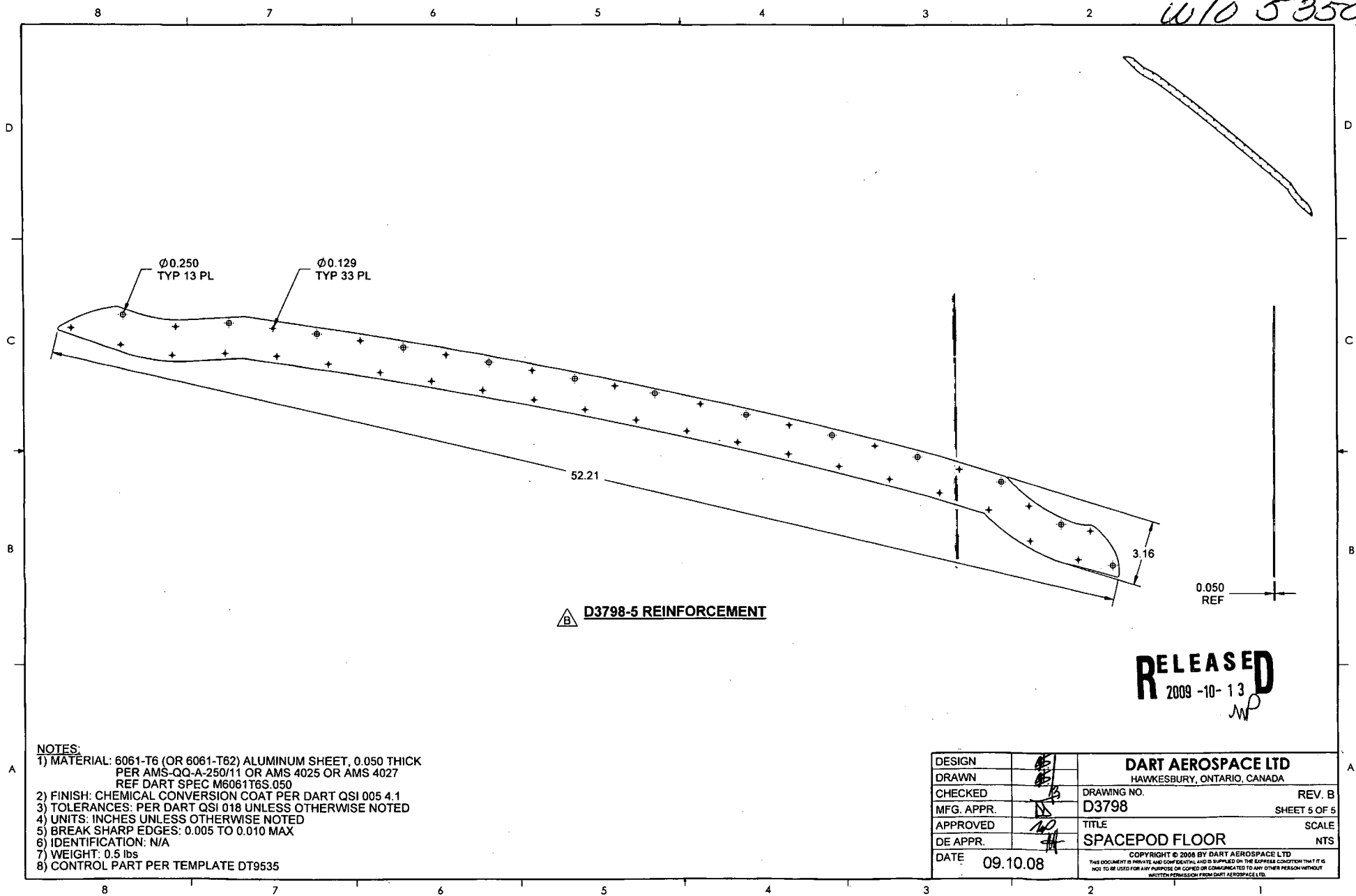
D3798-3 SPACEPOD FLOOR FOAM

RELEASED
2009-10-13

- NOTES:
- 1) MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK
REF DART SPEC M-4111N-S.125
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.5 lbs
 - 8) CONTROL PART PER TEMPLATE DT9433

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B SHEET 4 OF 5 SCALE NTS
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		TITLE	SPACEPOD FLOOR
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D3798-5 REINFORCEMENT

0.050
REF

RELEASED
2009-10-13
W/P

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.5 lbs
- 8) CONTROL PART PER TEMPLATE DT9535

DESIGN		DART AEROSPACE LTD	
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